

Work Order ID 74736

Wednesday, October 05, 2011 2:35:50 PM



Page 1

Item ID: D3622-11	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Ball Stud					
Start Date: 10/5/2011	Start Qty: 10.00		Cust Item ID:		
Required Date: 10/14/2011	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 11-0-5	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3622	C

100		Hardinge CNC LATHE SMALL	0.00			10	Ø		11/10/18
Hardinge		Memo	0.00						
Hardinge CNC Lathe Small		1-TURN AS PER FOLIO F969 & DWG D3622, FOLIO REV: DWG REV: 2-DEBURR AS REQUIRED							
110		QC2- Inspect parts off machine FAI/FAIB	0.00			10	Ø		11/10/18
QC		Memo	0.00						
Quality Control									
120		QC8- Inspect parts - second check	0.00			10	Ø		
QC		Memo	0.00						
Quality Control									

BA 11/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74736

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Wednesday, October 05, 2011 2:35:50 PM

Item ID: D3622-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Ball Stud

Start Date: 10/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST 70

0.00



Packaging

Memo

0.00

Packaging

(102)

11-10-19

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/19

ME

11-10-19

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, October 05, 2011 2:35:56 PM

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Work Order ID: 74736

Parent Item: D3622-11

Parent Item Name: Ball Stud




Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-09-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500  303 HEX BAR .500		Purchased	No			100	f	65.5300	0.108	1.136842			

0.855'

11/10/18

Location

Loc Qty

Loc Code

MAT037

65.53

65.53

109778

0.855'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

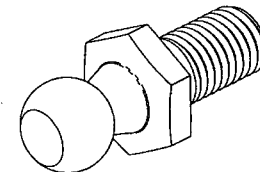
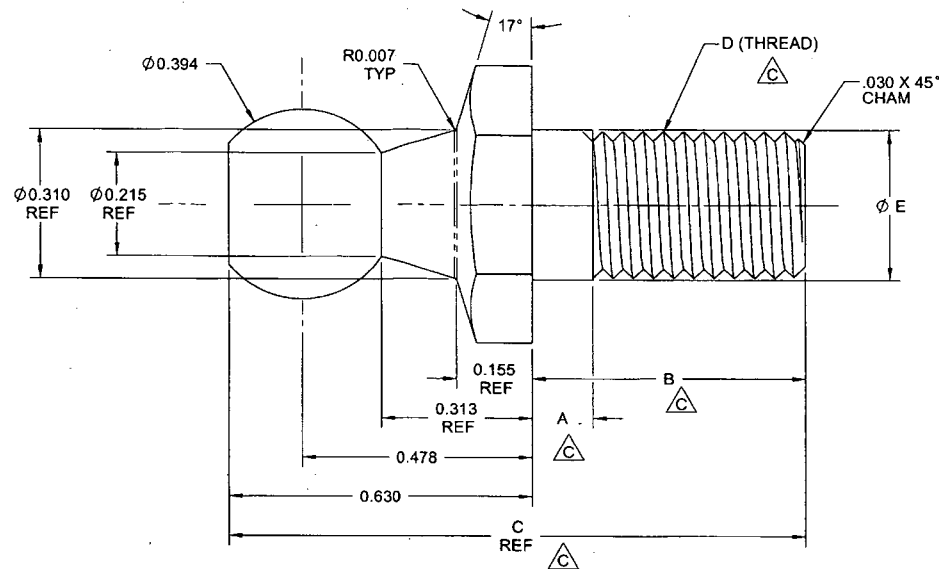
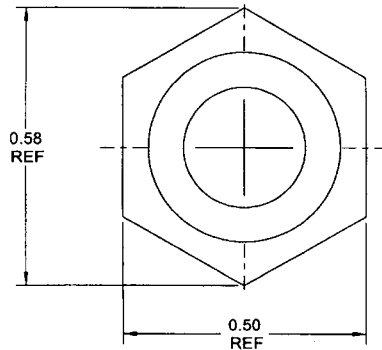
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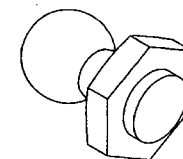
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**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E	
						MIN	MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **14736**

RELEASED
2010-09-23

- NOTES:
1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
7) WEIGHT: SEE D3622-X TABLE

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3622	SHEET 1 OF 1
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	BALL STUD	NTS
DATE	10.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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